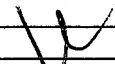
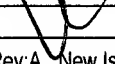


Date: Thursday, 04/01/2007 11:03:00 AM  
User: Linda Lacelle









**Process Sheet**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BLADE FITTING
<b>Job Number</b> : 30111	
<b>Estimate Number</b> : 12299	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3488041
<b>This Issue</b> : 04/01/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3488 / DSK101
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B / D
<b>Previous Run</b> : 29432	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 30/01/2007 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM	

**Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6103003	alum billet
		
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Alluminum Round Billet D6103-003 Batch: <u>30170</u>		
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
		
<b>Comment:</b> MORI SEIKI CNC LATHE LARGE 1-Turn as per Dwg DSK 101 & Folio FA625 2-Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA625 & Dwg D3488 2-Deburr		

*Handwritten:* BG 07.01.14 12  
BG 07.01.14 12  
SL 07/02/17 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/02/17	4	- 1 part scrap - part was placed on wrong side in jig - operator error	J.L 07/02/17	Scrap: destroy No replace	J.L 07/02/17	07/02/17	Q51012	07/02/17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/22

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 04/01/2007 11:03:00 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 30111

Part Number: D3488041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/ER

07/02/17

(11)

6.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MS

07/02/17

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS/ER

07-02-19

(11)

8.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103141

MS/ER

07/02/20

(11X)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.M.

07/02/21

(11)

10.0	ALS71032225	INSERT
------	-------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert

M19393

Q.M.

07/02/21

(11)

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

Q.M.

07/02/21

(11)

12.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------




Comment: INSPECT WORK TO CURRENT STEP

M101022

(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 07/02/22

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 04/01/2007 11:03:00 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 30111

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR

a.m

01/02/21

(32)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(11)  
207/02/22

Job Completion



U 02-02-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

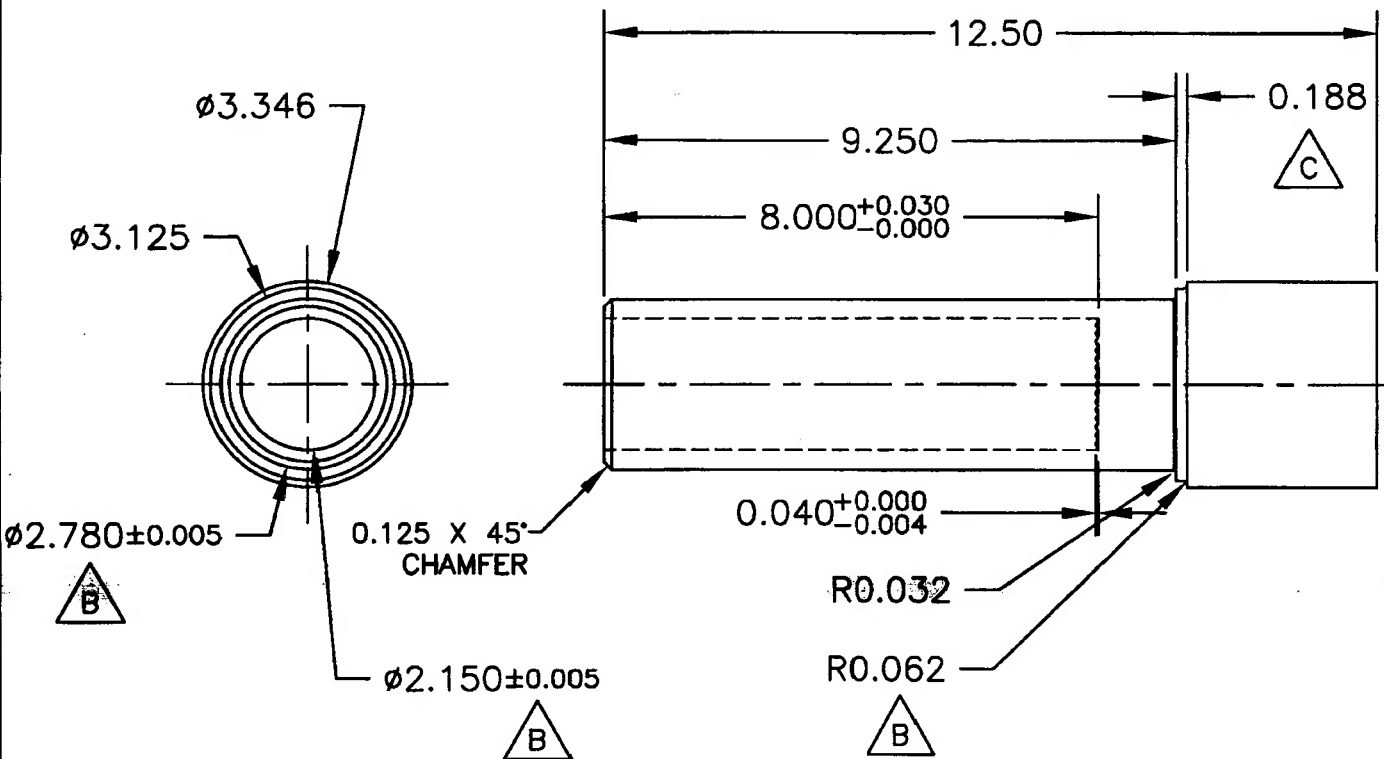
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
04	04	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. D
04	04	DSK 101	SHEET 1 OF 1
DATE	TITLE	SCALE	
06.05.09	DS488-1/-2 TURNING DETAIL	1:3	
A	05.12.21	NEW ISSUE	
B	06.03.02	ADD TOLERANCES AND RADIUS	
C	06.04.17	0.188 WAS 0.125	
D	06.05.09	REMOVE DIAMETER FOR CHAMFER	



DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

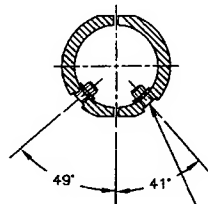
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

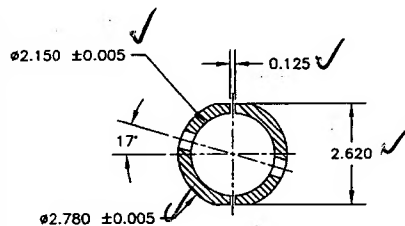




SECTION B-B

Ø0.297 ✓  
C'BORE Ø0.430 x 0.100 ✓  
INSTALL ALS4-1032-225 (OR AKS4-1032-225  
OR ALS7-1032-225 OR AKS7-1032-225)  
INSERTS AFTER FINISH  
(4 PLACES)

4



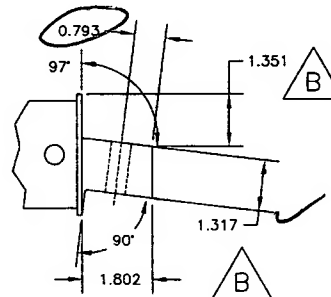
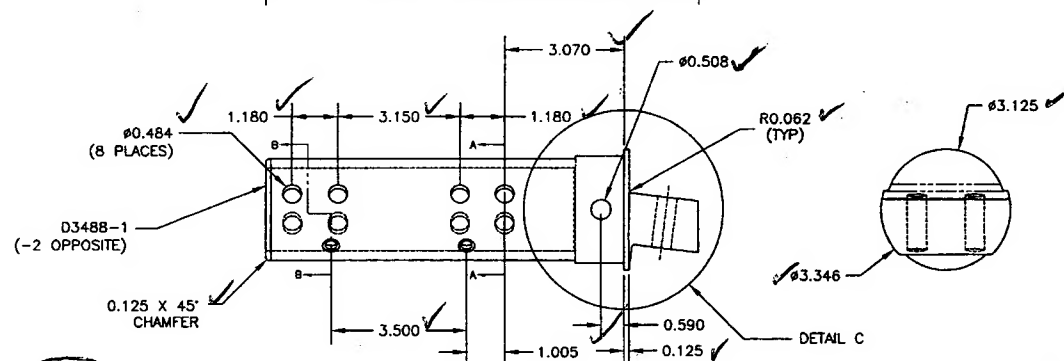
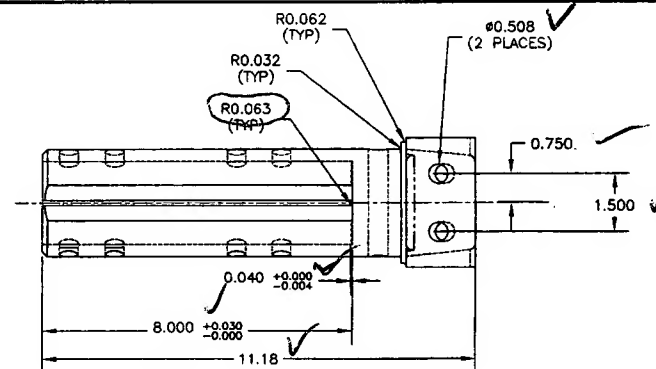
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED  
06.03.15 PH  
PER OS  
EIN #784

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	PH	DRAWING NO. D3488
DATE	06.03.15	TITLE BLADE FITTING
		REV. B SHEET 1 OF 1 SCALE 1:3

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11/02/11

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30161
<b>Description:</b> Blade Fitting, LH		<b>Part Number:</b> D3488-1
<b>Inspection Dwg:</b> D3488 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.125	—			
2.620	+/-0.010	2.624	—			
1.351	+/-0.010	1.341	—		HG	
1.317	+/-0.010	1.316	—			
90°	+/-0.1°	90°	—			
1.802	+/-0.010	1.805	—		HG	
Ø0.508	+0.006/-0.001	0.509	—			
R0.062	+/-0.010	0.062	—			
1.500	+/-0.010	1.497	—			
8.000	+0.030/-0.000	8.000	—			
11.18	+/-0.030	11.174	—		HG	
Ø0.484	+0.005/-0.001	0.485	—			
1.180	+/-0.010	1.177	—			
3.150	+/-0.010	3.149	—			
3.070	+/-0.010	3.064	—			
0.590	+/-0.010	0.589	—			
0.125	+/-0.010	0.129	—			
1.005	+/-0.010	1.000	—			
3.500	+/-0.010	3.501	—			
Ø0.297	+0.005/-0.000	0.299	—			
Ø0.430	+/-0.010	0.430	—			
0.100	+/-0.010	0.095	—			

<b>Measured by:</b> SC/Er	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/02/16	<b>Date:</b> 07/02/16	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	